

Work Order ID 72831

Tuesday, August 16, 2011 9:14:23 AM



Page 1

Item ID: D3720-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 8/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 8-16-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3720	Rev A

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3720 Dwg Rev: *[Signature]* Prog Rev: *[Signature]* 12-

Deburr if necessary

6061 - 128

B 11-8-18

(2)

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 11-8-18

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5/10/08/18

(X12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

C'sink as per dwg D3720

8/11/08/18 (12)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/10/08/18

(x12)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

12 X Ø M 7/11/08/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3720-1

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Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 8/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 of 11/08/22

170

Identify as per dwg & Stock Location: G-A

0.00



Packaging

Memo

0.00

Packaging

EP 11/08/22 (12)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/22

11-08-22 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, August 16, 2011 9:14:29 AM

Page 1

Work Order ID: 72831



Parent Item: D3720-1



Parent Item Name: Step Spacer



Start Date: 8/16/2011

Required Date: 8/26/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev :A New Issue 08-01-11 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 		Purchased	No			100	sf	132.6514	0.085	0.894737	1		
6061-T6 .125 Sheet										1818-18			

Location

Loc Qty

Loc Code

MAT021

132.6513684

113608

77.17

116700

0.98136842

118217

54.5

116700

981368422

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	72831
Description: Step Spacer		Part Number:	D3720-1
Inspection Dwg: D3720 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.129	2		VIBOZ	
4.65	+/-0.030	4.662	2		V	
2.59	+/-0.030	2.594	2		V	
0.750	+/-0.010	.747	x		V	
0.300	+/-0.010	.305	x		V	
0.522	+/-0.010	.522	2		V	
0.992	+/-0.010	.990	2		V	
1.301	+/-0.010	1.303	2		V	
0.731	+/-0.010	.735	x		V	
0.888	+/-0.010	.884	x		V	
1.771	+/-0.010	1.766	2		V	
2.446	+/-0.010	2.446	2		V	
0.213	+/-0.010	.209	>		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-8-18	Date: 11/08/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/DD	DA

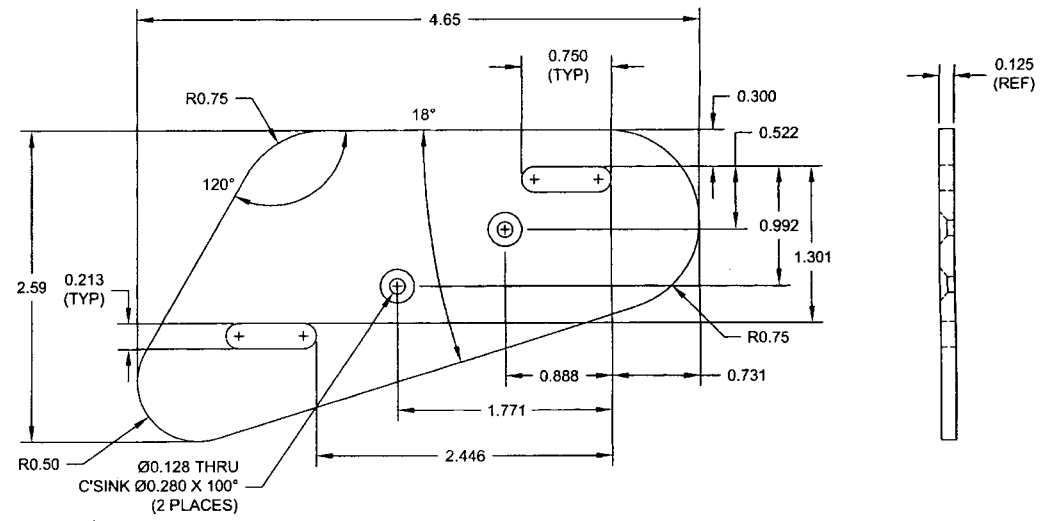
8 7 6 5 4 3 2 1

D

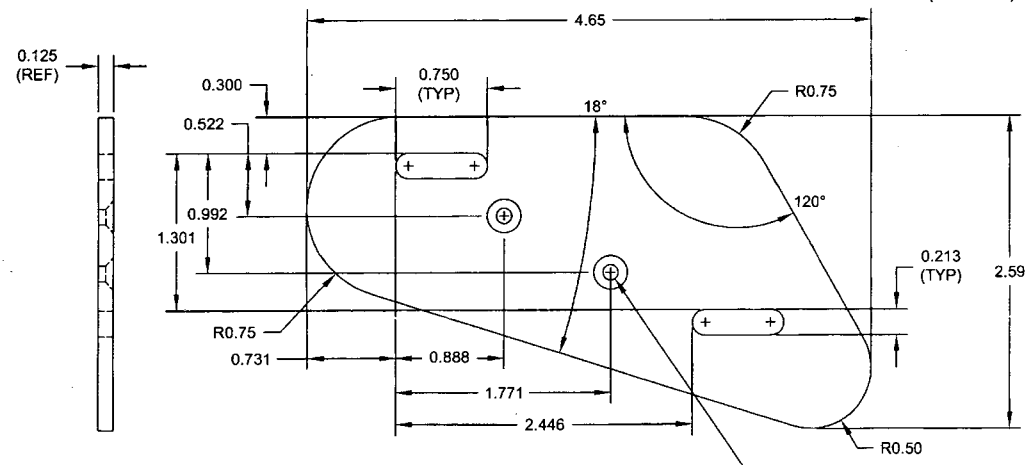
C

B

A



D3720-1 STEP SPACER



D3720-2 STEP SPACER

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR -T62) ALUMINUM SHEET 0.125 THICK (PER QQ-A-250/11 OR AMS 4025/4027) (REF DART SPEC M6061T6S.125)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.08 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72831

011-08-14

RELEASED
06-01-10

REV.	NEW ISSUE	PH	07.12.27
DESIGN	PH	BY	DATE
DRAWN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	LB		
MFG. APPR.	LB	DRAWING NO.	REV. A
APPROVED	LB	D3720	SHEET 1 OF 1
DE APPR.	LB	TITLE	SCALE
DATE	07.12.27	STEP SPACER	1:1
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